

# Work Order ID 73229

Friday, August 26, 2011 10:27:39 AM



Page 1

Item ID: D3315-5

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 8/26/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/08/26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B11-8-30

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-30

120

0.00



QC8- Inspect parts - second check

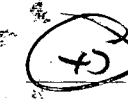
QC

Memo

0.00

Quality Control

8 wlog/31



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73229**

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Item Name: Wearplate

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1- Form using DT8751 Die as per Dwg D3315Rev: B2- Form using DT8179 Die as per Dwg D3315Rev: B

140

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld hard surface using D3315-5T3 as per QSI 004 and Dwg D3315 Rev: \_\_\_\_\_

Qty Part Number Description

Batch

A/R N/A

7560 Hardcoat Rod

M1177415B SB 11/09/025 11/09/06(X5)  
-5X5 11-09-13 JAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 73229

Friday, August 26, 2011 10:27:39 AM



Page 3

Item ID: D3315-5

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Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 8/26/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:50  
320  
9:20

0.00

Powder Coating

5

5

5x Ø m-l Novaly

m 117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 73229

Friday, August 26, 2011 10:27:39 AM



Page 4

Item ID: D3315-5

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 6 20 200/100  
counted  
measured

200

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:  
TCCA-PDA, Dart Aerospace Ltd.  
P/N: D3315-5, B/N: BXXXXX  
For Product Eligibility see PDA04-17  
and Stock  
Location: ST496A

5x8 11-09-14-

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/15   
MF 11-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, August 26, 2011 10:27:37 AM

Page 1

Work Order ID: 73229



Parent Item: D3315-5



Parent Item Name: Wearplate

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: A ☐ 05.05.12 ☐ New issue ☐ KJ/JLM ☐  
 IPP Rev:B As per Rev B 06-03-24 JLM  
 IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

134.3000

1.8345

9.655263



B11-8-30

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

134.3

116791

32.5

117500

101.8

117500

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	73229
<b>Description:</b> Wearplate		<b>Part Number:</b>	D3315-5
<b>Inspection Dwg:</b> D3315	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31	✓		T 1801	
30.215	+/-0.010	30.215	✓		T	
24.215	+/-0.010	24.215	✓		T	
21.611	+/-0.010	21.611	✓		T	
17.965	+/-0.010	17.965	✓		T	
16.026	+/-0.010	16.026	✓		T	
14.735	+/-0.010	14.735	✓		T	
12.815	+/-0.010	12.815	✓		T	
6.465	+/-0.010	6.465	✓		T	
5.464	+/-0.010	5.467	✓		V 1802	
4.527	+/-0.010	4.522	✓		V	
3.550	+/-0.010	3.551	✓		V	
5.214	+/-0.010	5.212	✓		V	
Ø0.300	+0.006/-0.001	0.303	✓		V	
Ø0.266 x 0.575	+/-0.010	266x580	✓		V	
Ø0.266 x 0.450	+/-0.010	268x455	✓		V	

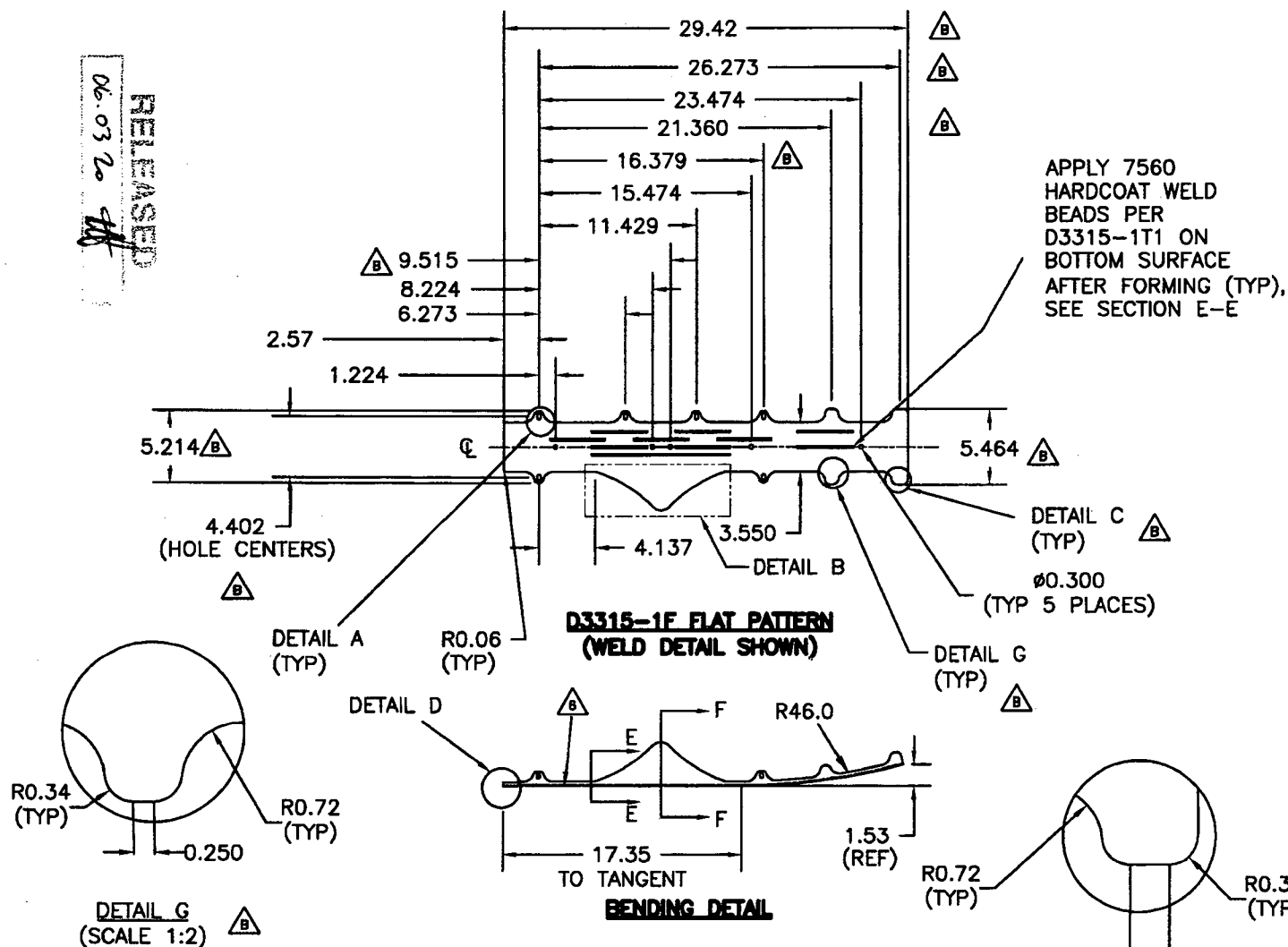
<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-8-30	<b>Date:</b> 11/08/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	DS

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3315
DATE	TITLE	SCALE
06.01.31	WEARPLATE	1:12
A	B	REVISION
04.09.10	06.01.31	NEW ISSUE
B		UPDATE DIMENSIONS

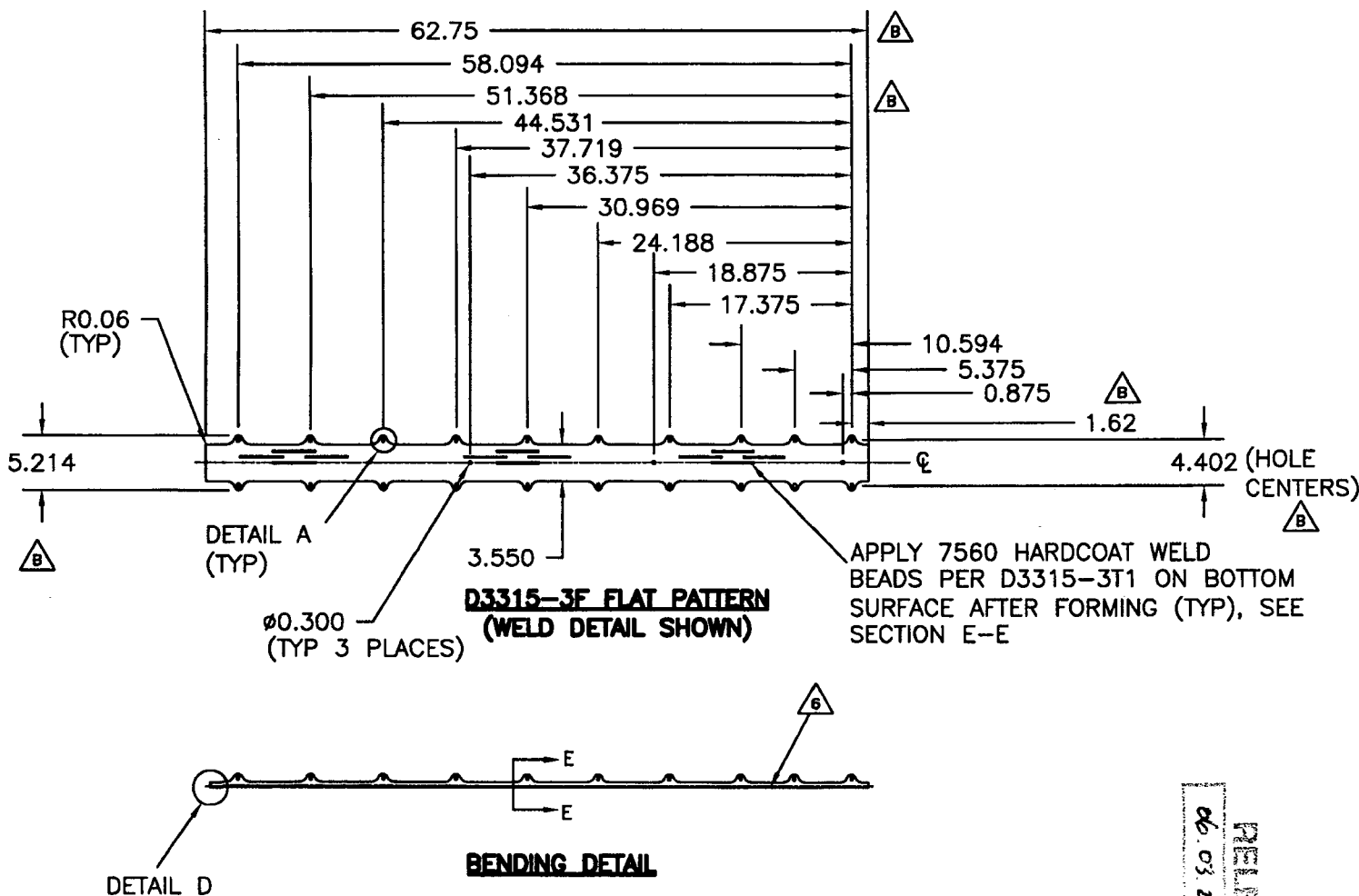
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06.03.20



**D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73227

**DART**

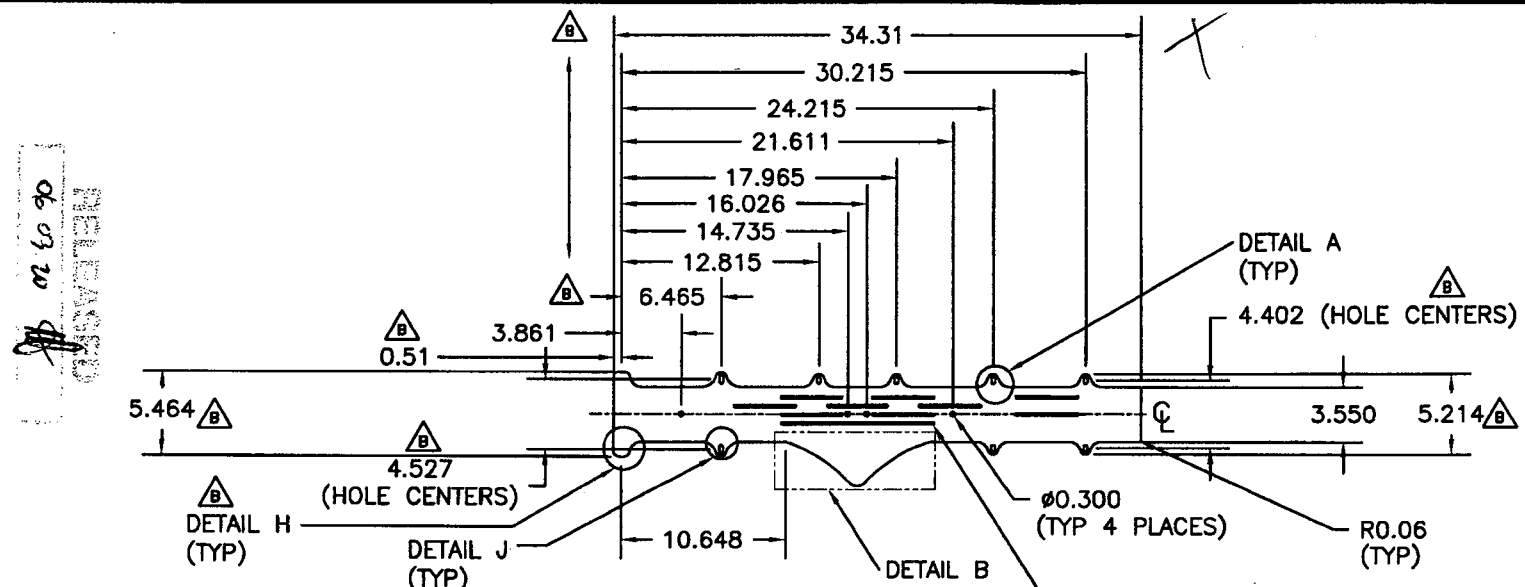
**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	TITLE	REV. B
PH	PH	D3315	SHEET 2 OF 4
CHECKED	APPROVED	WEARPLATE	SCALE
06.01.31			1:16

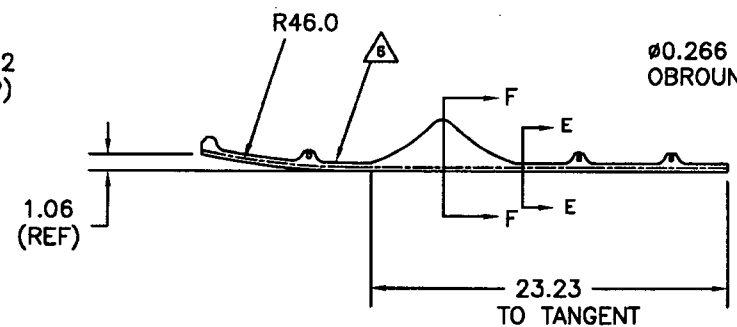
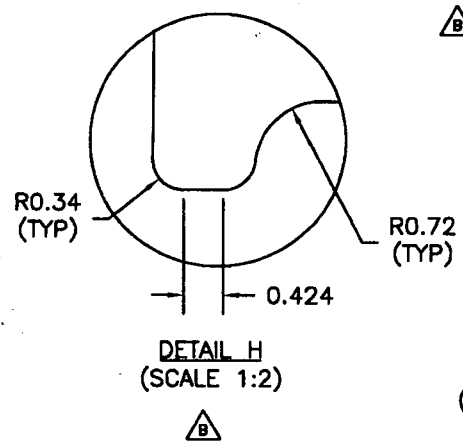
RELEASED  
26 03 20

**DART**

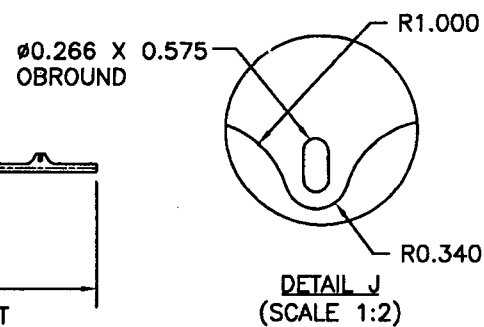


**D3315-5F FLAT PATTERN  
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD  
BEADS PER D3315-5T1 ON BOTTOM SURFACE  
AFTER FORMING (TYP), SEE SECTION E-E



**BENDING DETAIL**



**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSION ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	D3315	DRAWN BY	DART AEROSPACE LTD
CHECKED	[Signature]	APPROVED	[Signature]
DATE	06.01.31	DRAWING NO.	D3315
		TITLE	WEARPLATE
		SCALE	1:12
		REV. B	SHEET 3 OF 4
			HAWKESBURY, ONTARIO, CANADA

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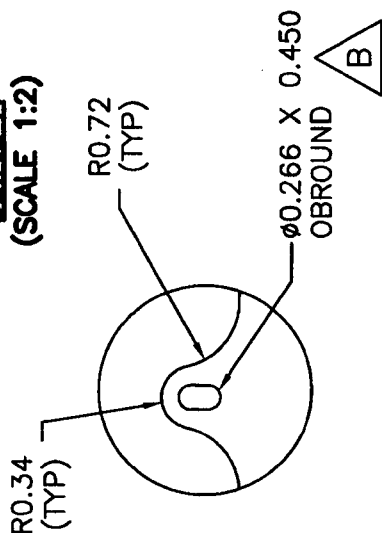
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06.03.20

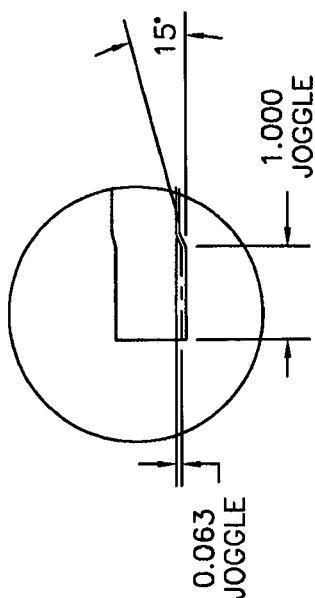


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31	TITLE WEARPLATE		SCALE NTS

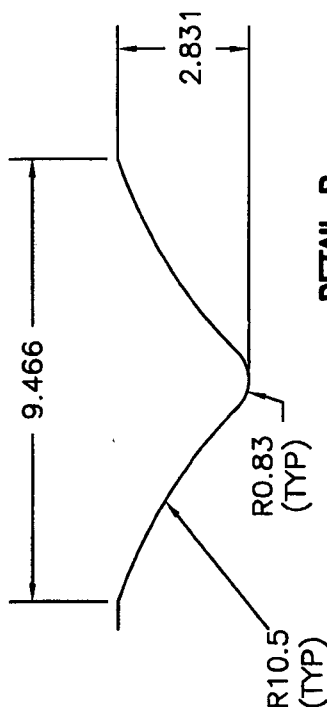
**DETAIL A**  
(SCALE 1:2)



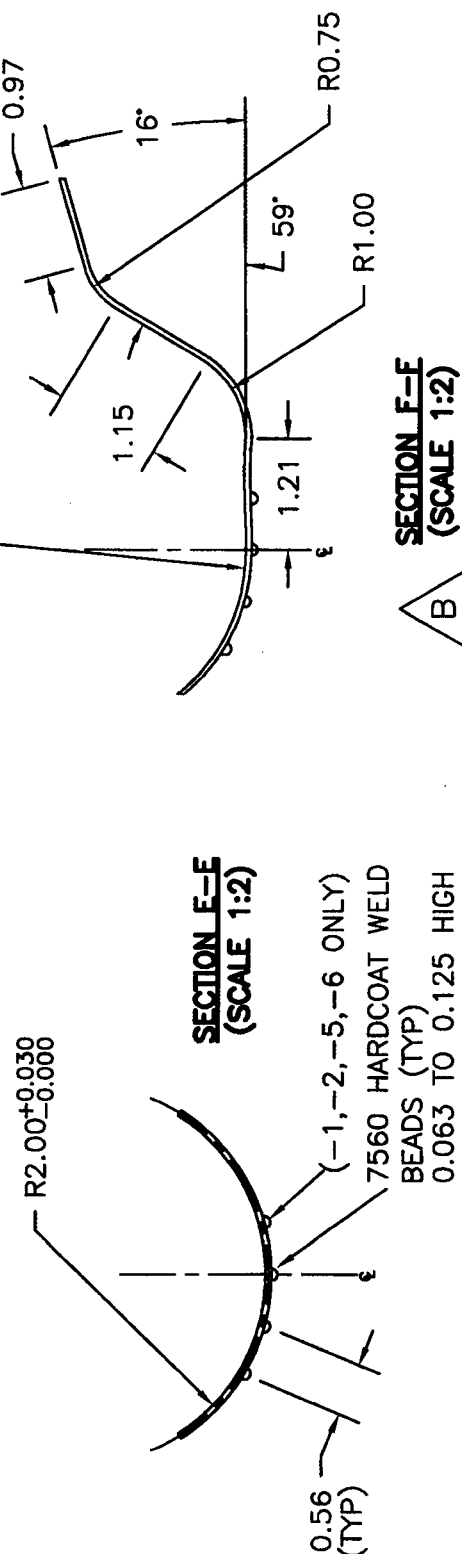
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(SCALE 1:2)



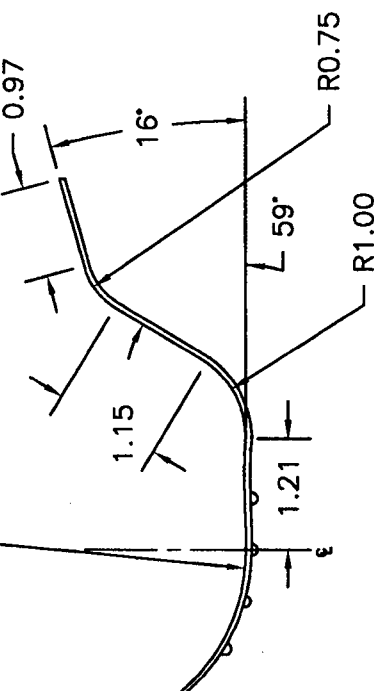
**DETAIL B**  
(SCALE 1:4)



**SECTION E-E**  
(SCALE 1:2)



**SECTION F-F**  
(SCALE 1:2)



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06.03.20

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